

Work Order ID 92234 - 2 split
Tuesday, October 23, 2012 4:13:20 PM

92234

Page 1

Item ID: PB67-43001-03

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012 Start Qty: 2.00

2

Required Date: 11/30/2012 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-10-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

B57-43001-03

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2. ~~242~~ THREADLOCK batch: 120369

262 22 121212

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Memo

0.00

Packaging

1 φ

12-12-19

DAS 16

12/2/15

1

12/12/05 JB

12/12/19

DAS 06

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Item ID: PB67-43001-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/30/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS 12-12-19

u 12.12.19

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev C 10.09.24 as per Rev
C dwg EC verified by:DD IPP Rev:D 10.10.21 added NAS1149F0532P DD ver:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3922-1 Clip		Manufactured	No				Each	39.0000		2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st073			39						
				66852			39						
MS17984- C408 PIN, QUICK RELEASE		Purchased	No				Each	5.0000					
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST314			5						
				112940			5						
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	159.0000	8	16			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				122089			81						
				122089			81						
				ST400			78						
				115827			78						
30345T21 LANYARD		Purchased	No			100	Each	31.0000	1	2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST401			31						
				17828			31						
30345T24 LANYARDS		Purchased	No			100	Each	37.0000	3	6			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST401			37						
				112853			37						

JB

66852

123482 JB

JB

13X122089

JB

17828

JB 12/12/05

112853

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

3408A98 Purchased No

100 Each 12.0000

1

2

JB

DETENT BALL SPRING PLUNG

Location

Loc Qty

Loc Code

ST401

12

111078

2

115703

10

115703

AN4-10A

Purchased No

100 Each 94.0000

2

4

JP

Bolt

Location

Loc Qty

Loc Code

ST355

50

122407

50

ST356

44

117619

4

122800

40

122800

AN4-13A

Purchased No

100 Each 916.0000

1

2

123522 JB

12/12/02

Bolt

Location

Loc Qty

Loc Code

ST356

803

122416

281

122808

22

122993

500

ST357

113

120187

19

120770

12

121652

81

122063

1

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Work Order ID: 92234

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

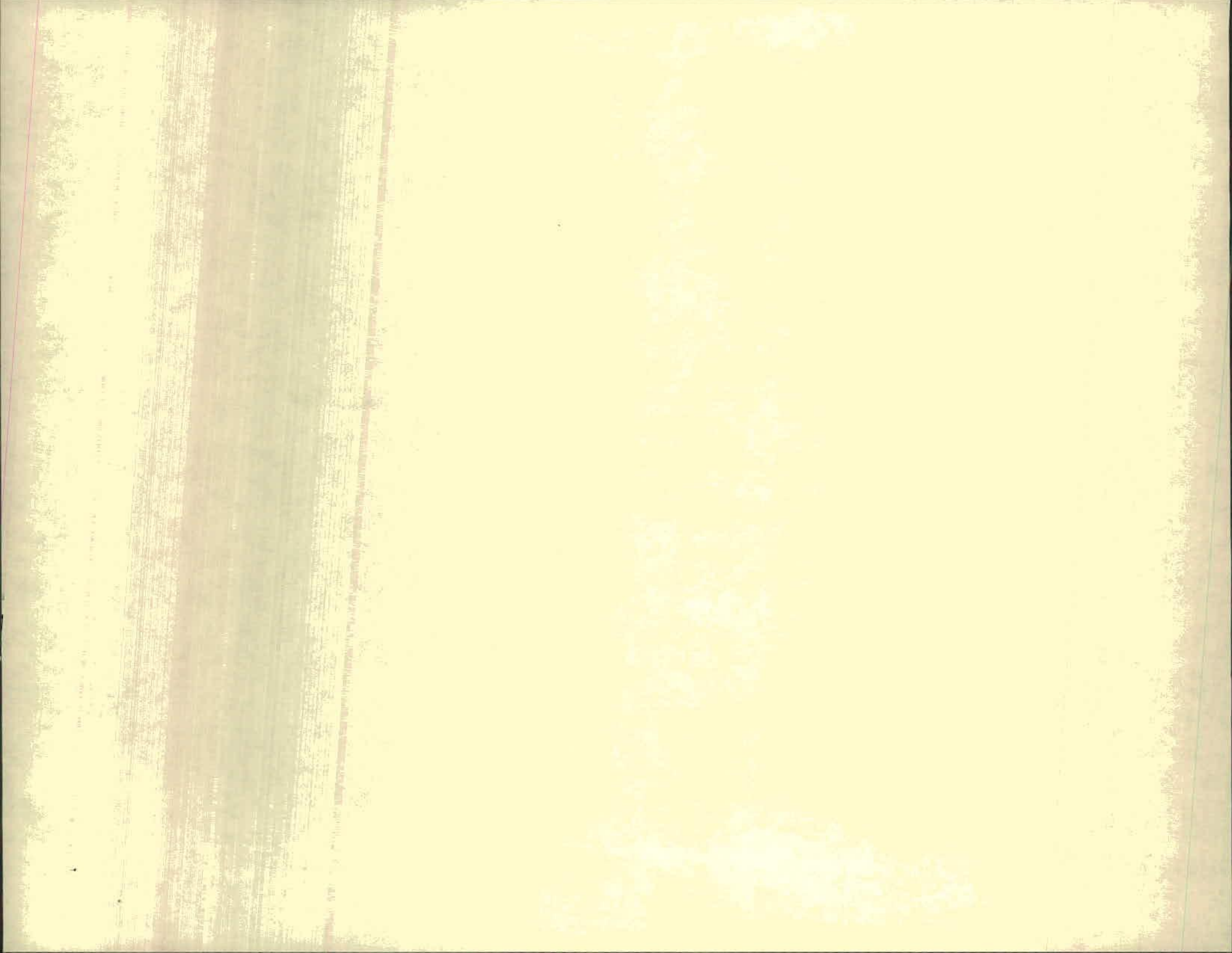
Required Qty: 2.00

AN4-15A Bolt	Purchased	No	100	Each	404.0000	4	8	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	100				
			120449	100				
			ST357	287				
			122800	87				
			123021	200				
			ST358	17		123021		
			118706	3				
			120422	1				
			122141	13				
AN5-26A Bolt	Purchased	No	100	Each	15.0000	1	2	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST339	15				
			112492	15		112492		
AN6-11A BOLT	Purchased	No	100	Each	65.0000	2	4	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST341	65				
			111177	15				
			114437	50		114437		
AN6-16A BOLT	Purchased	No	100	Each	31.0000	2	4	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST341	31				
			111636	31		111636		
AN8-13A BOLT	Purchased	No	100	Each	10.0000	2	4	✓ JB 12/17/05
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST343	10		123482		
			110915	10				

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Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

BSP43 Purchased No 100 Each 39.0000 3
RIVET
123482 JB

Location	Loc Qty	Loc Code
ST284	39	
110704	36	
111127	3	

CR3213-4-05 Purchased No 100 Each 738.0000 1 2 JB
cherry rivet

Location	Loc Qty	Loc Code
ST328	600	
123301	600	
ST331	138	
108473	38	
108991	100	

D3440-1 Manufactured No 100 Each 9.0000 1
Tube Guide (Supersedes B67-43001-25/-307)
108991
42256 JB
40049

Location	Loc Qty	Loc Code
ST439A	9	
40047	8	
41347	1	

D3440-3 Manufactured No 100 Each 1.0000 1
Clamp (Supersedes B67-43001-309)
92256 JB

Location	Loc Qty	Loc Code
ST439A	1	
41348	1	

D3444-1 Manufactured No 100 Each 6.0000 1
Velcro Loop Belt
55548 JB

Location	Loc Qty	Loc Code
ST439A	6	
41457	6	

41457

12/12/05

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Work Order ID: 92234
Parent Item: PB67-43001-03
Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012 Required Date: 11/30/2012
Start Qty: 2.00 Required Qty: 2.00

D3447-9 Manufactured No 100 Each 4.0000
Swing Arm

2 92253 JB

Location	Loc Qty	Loc Code
ST440	4	
62127	4	

D3449-1 Manufactured No 100 Each 4.0000
Pad

1 92257 JB

Location	Loc Qty	Loc Code
ST440	4	
62128	4	

D3451-043 Manufactured No 100 Each 0.0000
Handle and Lock-Down Assembly

1 92260 JB

D3451-045 Manufactured No 100 Each 0.0000
Handle and Lock-Down Assembly

2 92261

MS17984-C418 Purchased No 100 Each 15.0000
PIN, QUICK RELEASE

3 123482 JB

Location	Loc Qty	Loc Code
ST315	15	
114416	2	
114523	13	

MS21042L4 Purchased No 100 Each 6,806.0000
Nut

9 18 JB 12/12/05

Location	Loc Qty	Loc Code
314	1279	
122452	1279	
ST300	27	
119017	20	
121444	7	
ST314	5500	
123021	3000	
123248	900	
123355	1600	

123021

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

100

Each

1,211.0000

1

2

Nut

Location

Loc Qty

Loc Code

300

131

121652

131

314

1000

122452

1000

ST300

80

108827

4

116105

1

116548

43

119109

20

2937

12

122452

MS21042L6

Purchased

No

100

Each

1,093.0000

4

8

Nut

Location

Loc Qty

Loc Code

314

314

122441

314

ST300

279

117677

25

118384

3

118927

48

119075

4

120308

199

ST314

500

123248

350

123355

150

120308

MS24694-S109

Purchased

No

100

Each

48.0000

2

4

Screw, Flat Head

Location

Loc Qty

Loc Code

Mezz

48

115708

48

115708

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-07

Purchased

No

100

Each

44.0000

1

Screw

Location

Loc Qty

Loc Code

ST291

44

18106

44

MS27039-1-23

Purchased

No

100

Each

27.0000

1

SCREW

Location

Loc Qty

Loc Code

ST291

27

18057

27

MS51859-6

Purchased

No

100

Each

96.0000

8

WASHER

Location

Loc Qty

Loc Code

ST296

96

111279

8

112940

88

MS51859-7

Purchased

No

100

Each

36.0000

2

Washer

Location

Loc Qty

Loc Code

ST295

20

122141

20

ST296

16

111193

6

120518

10

MS51859-8

Purchased

No

100

Each

28.0000

8

WASHER

Location

Loc Qty

Loc Code

ST296

28

112940

28

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0316P

Purchased

No

100

Each

233.0000

1

2

WASHER

Location

Loc Qty

Loc Code

ST275

233

112940

33

113237

100

113644

100

112940

NAS1149F0432P

Purchased

No

100

Each

672.0000

16

32

Washer

Location

Loc Qty

Loc Code

275

588

122441

588

ST275

84

121350

15

122151

69

123522

NAS1149F0532P

Purchased

No

100

Each

1,103.0000

2

4

WASHER

Location

Loc Qty

Loc Code

ST275

1103

18057

1103

18057

NAS1149F0632P

Purchased

No

100

Each

447.0000

8

16

WASHER

Location

Loc Qty

Loc Code

ST275

447

18057

447

18057

NAS1149F0832P

Purchased

No

100

Each

244.0000

2

4

WASHER

Location

Loc Qty

Loc Code

ST275

244

18057

244

18057

12/12/05

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Work Order ID: 92234

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

NAS43DD3-61

Spacer

Purchased

No

100

Each

9.0000

1

2

JB

Location

Loc Qty

Loc Code

ST1278

9

122204

9

122204

PB67-43001-09

Aft Blade Fold Assembly Weldment

Manufactured

No

100

Each

1.0000

1

2

92/21

Location

Loc Qty

Loc Code

WA

1

88055

1

PB67-43001-13

Aft Adjustable Blade Support Assembly

Manufactured

No

100

Each

0.0000

1

2

92 119

PB67-43001-135

Male Eye

Manufactured

No

100

Each

4.0000

1

2

122204 JB

Location

Loc Qty

Loc Code

ST446

4

45000

4

PB67-43001-137

Locking Sleeve

Manufactured

No

100

Each

2.0000

1

2

1845000 90904 JB

Location

Loc Qty

Loc Code

ST446A

2

85103

2

PB67-43001-155

Pin

Manufactured

No

100

Each

11.0000

1

2

JB 12/12/05

Location

Loc Qty

Loc Code

ST446A

11

43092

11

PB67-43001-17

Aft Adjustable Blade Support Assembly

Manufactured

No

100

Each

0.0000

1

2

43092

PB67-43001-21

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

92 119

PB67-43001-23

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

2

B92113 (2)

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Work Order ID: 92234

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-261

Lever Arm

Manufactured No

100 Each 8.0000

2

90931

JB

Location

Loc Qty

Loc Code

ST432

8

62182

8

PB67-43001-265

Deltin Bushing

Manufactured No

100 Each 14.0000

5

10

90932 JB 12-12-12

Location

Loc Qty

Loc Code

ST438

2

40056

2

WA

12

85184

12

PB67-43001-299

Bushing

Manufactured No

100 Each 13.0000

2

4

90933 JB 12-12-12

Location

Loc Qty

Loc Code

ST439A

13

44969

13

PB67-43001-305

Bearing

Manufactured No

100 Each 1.0000

1

90934 JB

Location

Loc Qty

Loc Code

ST439

1

47044

1

PB67-43001-37

Tube Arm Assembly

Manufactured No

100 Each 1.0000

1

92110 JB

Location

Loc Qty

Loc Code

ST446

1

88058

1

PB67-43001-57

Stabilizer Arm

Manufactured No

100 Each 1.0000

1

92100 JB

12/12/05

Location

Loc Qty

Loc Code

ST209a

1

88053

1

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Work Order ID: 92234

Parent Item: PB67-43001-03

Start Date: 10/23/2012

Required Date: 11/30/2012

Parent Item Name: Aft Blade Fold Assembly

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-59

Manufactured No

100

Each

1.0000

1

2

PB67-43001-59

Location

ST437A

892103-2

Loc Qty

1

Loc Code

88054

1

PB67-43001-63

Manufactured No

100

Each

1.0000

1

Handle Assembly

Location

WA

Loc Qty

1

Loc Code

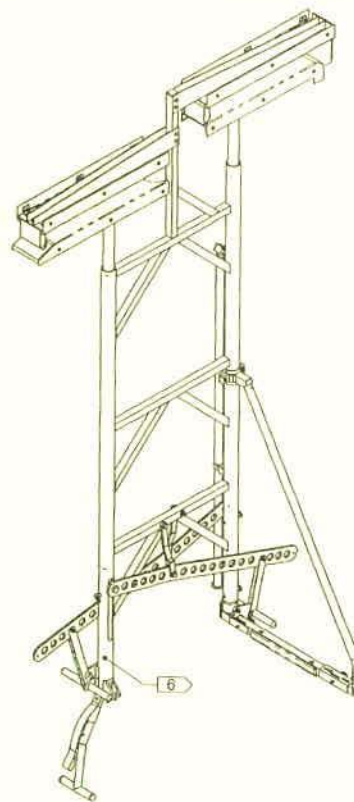
88056

1

92099 JB 12/12/05

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELRI BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3446-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3447-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345721	LANYARD
26	3	30345724	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
28	2	AN4-10A	BOLT
29	1	AN4-12A	BOLT
30	4	AN4-15A	BOLT
31	1	AN5-26A	BOLT
32	2	AN6-11A	BOLT
33	2	AN6-16A	BOLT
34	2	AN8-13A	BOLT
35	3	BSP43	RIVET
36	1	CR32134-05	RIVET
37	8	MS171E34	SPRING SLOTTED TENSION PIN (OR 240-107)
38	1	MS170E-C408	QUICK RELEASE PIN
39	3	MS170E-C418	QUICK RELEASE PIN
40	9	MS21042L4	NUT
41	1	MS21042L5	NUT
42	4	MS21042L6	NUT
43	2	MS24694-S109	SCREW
44	1	MS27039-1-07	SCREW
45	1	MS27039-1-23	SCREW
46	8	MS51859-6	NYLON WASHER
47	2	MS51859-7	NYLON WASHER
48	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



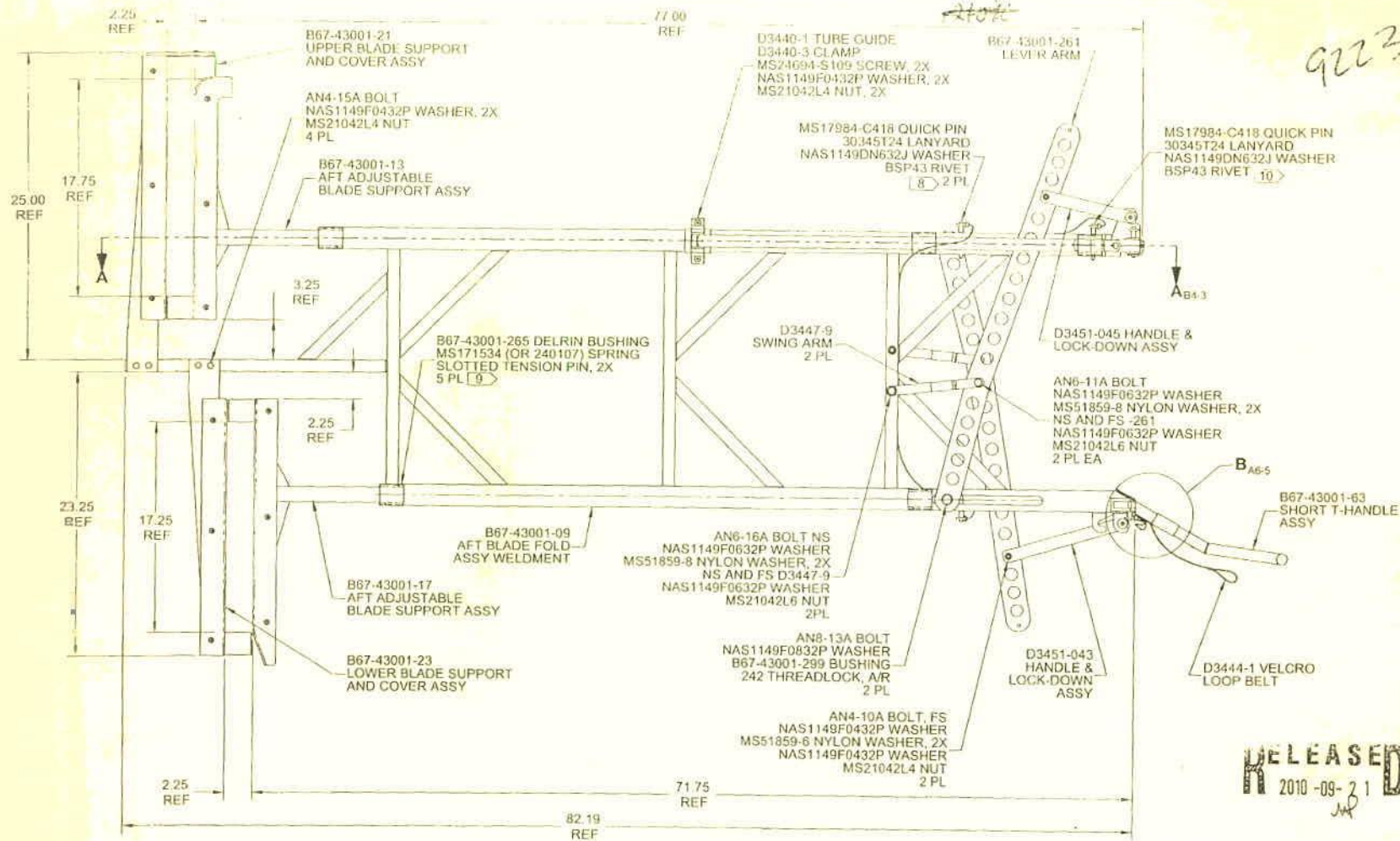
B67-43001-03 AFT BLADE FOLD ASSY

- NOTES
- 1) MATERIAL - NONE
 - 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
 - 7) WEIGHT: 50.57 lbs
 - 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL
 - 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
 - 10) DRILL $\phi 0.250$ DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
 - 12) DRILL A $\phi 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
 - 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A $\phi 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
 - 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

92234 MJS
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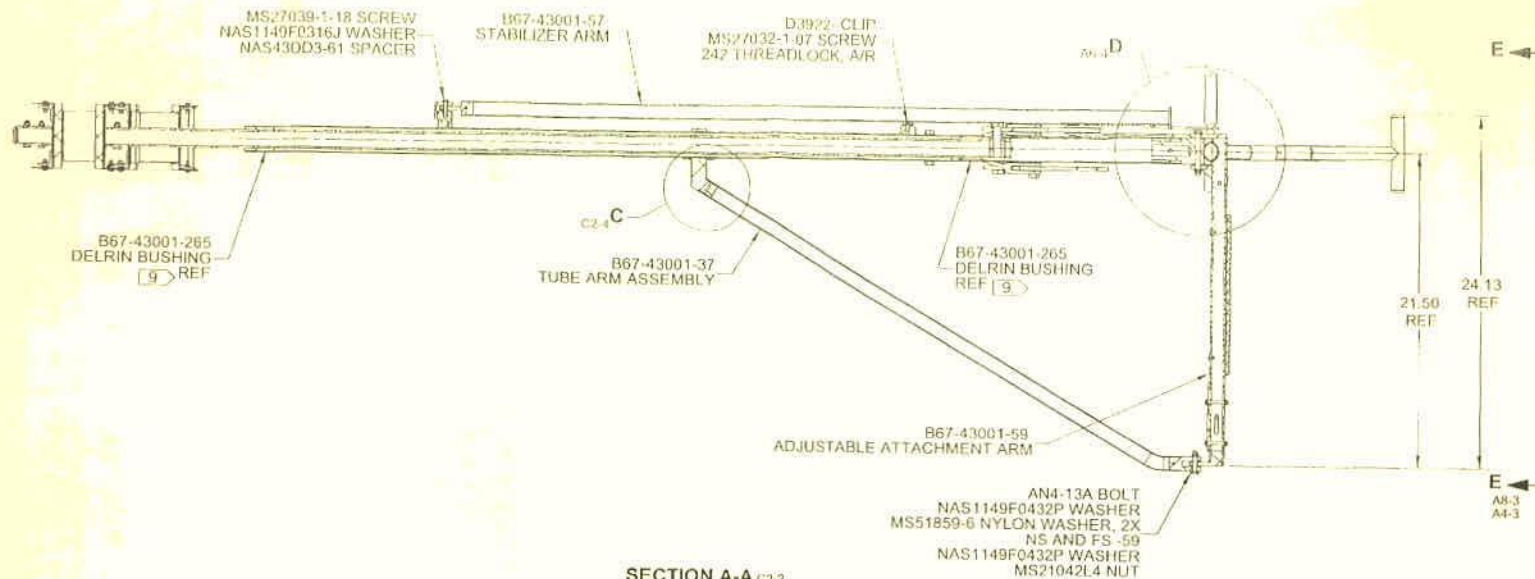
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2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043 FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001 REASON: SEE PAR#09-011	VS	10.06.14
REV	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV: C
MFG. APPR.		B67-43001-03	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	VA	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DRAWING IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

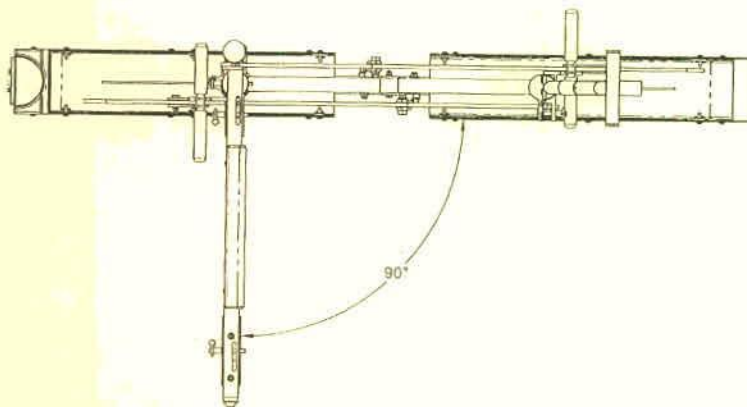


B67-43001-03 AFT BLADE FOLD ASSY

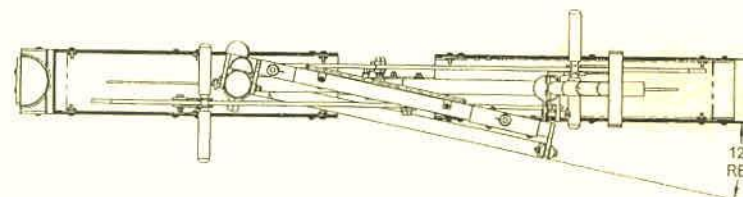
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	J	B67-43001-03	SHEET 2 OF 5
APPROVED	J	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	MTS
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SECTION A-A C2-2



C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION [10]



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION [10]

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2010-09-21

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DRAWN	VS		
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MFG. APPR		B67-43001-03	SHEET 3 OF 5
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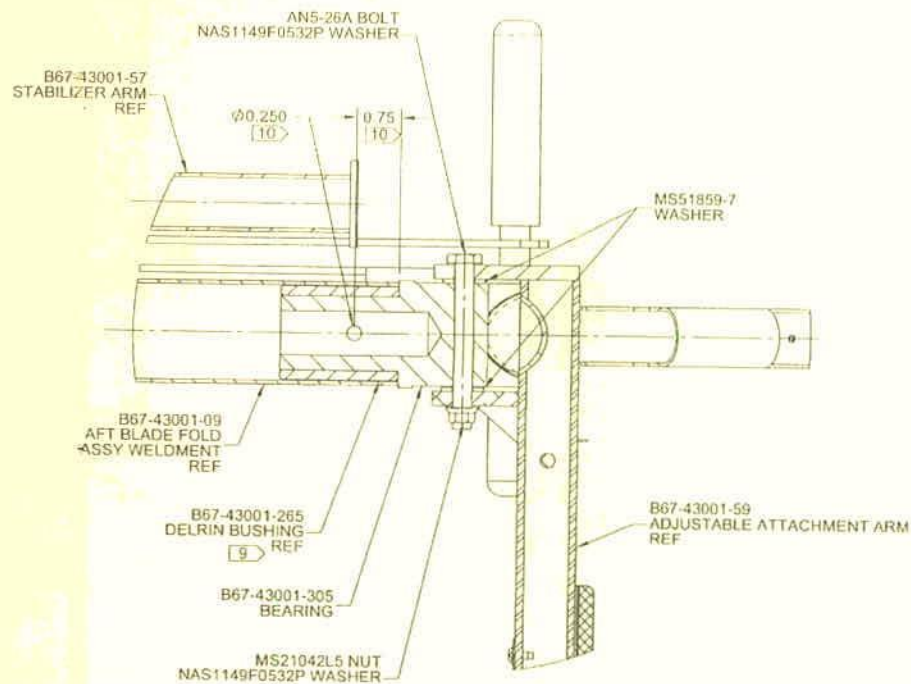
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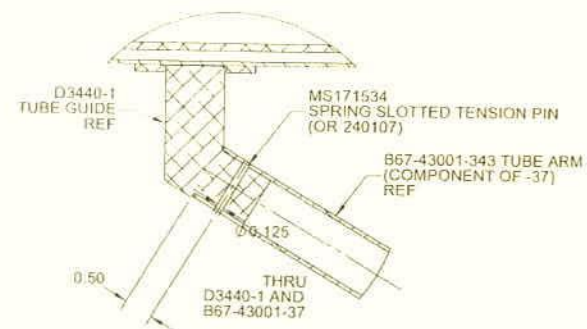
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DETAIL D
SCALE 5X D3-3

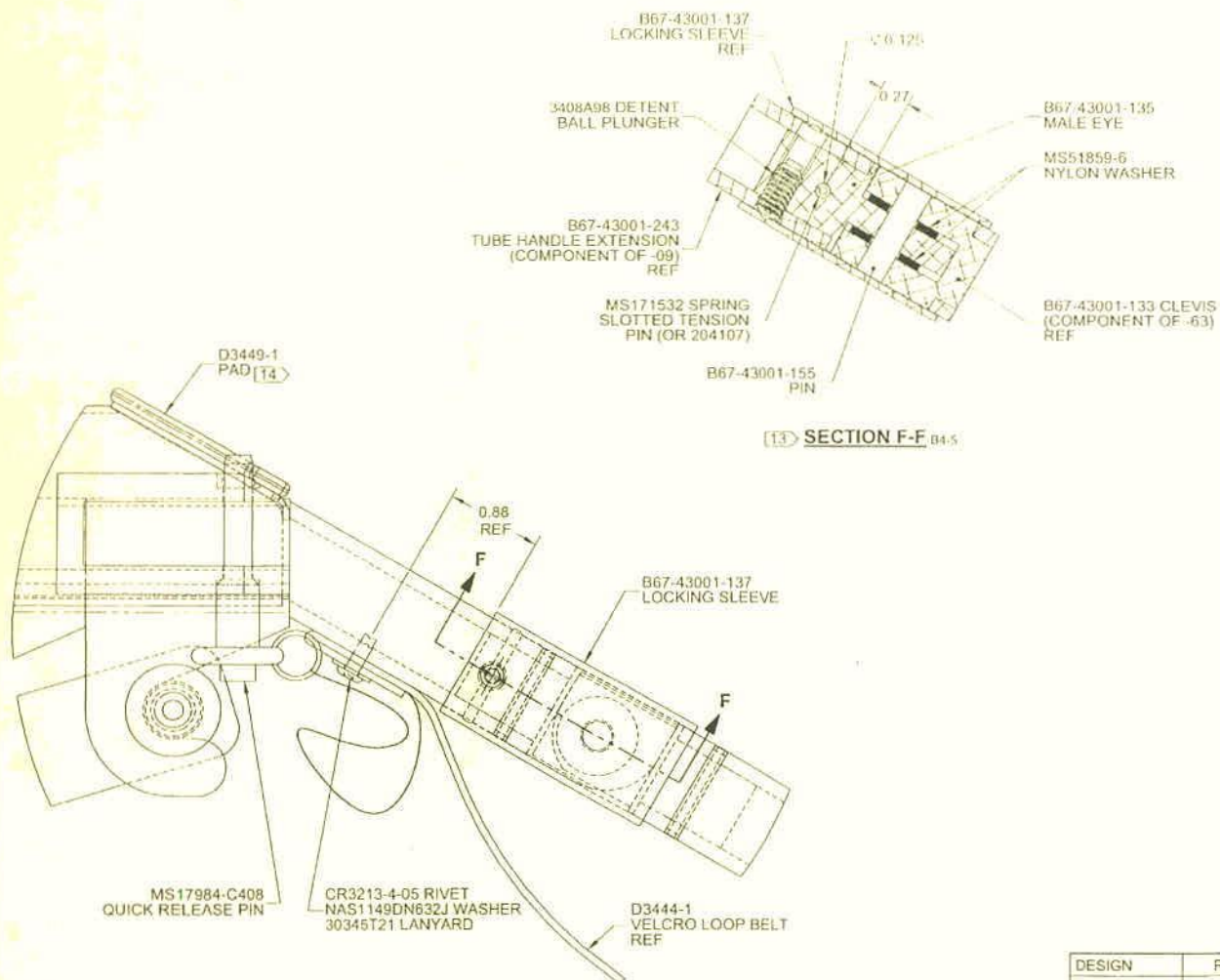


DETAIL C D5-3
SCALE 5X

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DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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[13] **DETAIL B** C2-2
SCALE 10X

[13] **SECTION F-F** B4-5

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MFG. APPR.		B67-43001-03	SHEET 5 OF 5
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